

Work Order ID 74352

Wednesday, September 28, 2011 3:23:57 PM



Page 1

Item ID: D2661-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, LH Fwd Aft Out 206

Start Date: 9/28/2011 Start Qty: 20.00

Cust Item ID:

Required Date: 10/7/2011 Req'd Qty: 20.00

Customer:

Reference:

Approvals:

Process Plan: M.L.J

Date: 11/09/28 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2661

Rev D

100



HAAS 1

HAAS CNC VERTICAL MACHINING #1

0.00

mf/28 11.10.23

20

✓

0.00

Memo

HAAS CNC vertical machine #1

Program part number and batch number. ☐ Fixturing Inspection last completed
11/16/24 by mf ☐ 1-Machine Step No 1 of Folio and visually inspect as
 per attached Dimension Sheet ☐ 2-Machine Step No 2 of Folio and visually
 inspect as per attached Dimension

110



Mill Conv

CONVENTIONAL MILLING MACHINE

0.00

mf/28 11.10.24

20

✓

0.00

Memo

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

120



QC

QC2- Inspect parts off machine FAI/FAIB

0.00

mf/28 11.10.24

20

✓

0.00

Memo

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____






NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Work Order ID 74352




Wednesday, September 28, 2011 3:23:57 PM

Page 2

Item ID:	D2661-1	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Saddle, LH Fwd Aft Out 206					
Start Date:	9/28/2011	Start Qty:	20.00		Cust Item ID:	
Required Date:	10/7/2011	Req'd Qty:	20.00		Customer:	

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		BA 11/10/27		20	4		
140  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				20	BR 11-10-28		
150  Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo	0.00 0.00				20	X M- 11/10/31		

START TIME: 11:45
FINISH TIME: 12:15
OVEN TEMPERATURE: 320°F

M 117745

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 74352

Page 3

Wednesday, September 28, 2011 3:23:57 PM

Item ID: D2661-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, LH Fwd Aft Out 206

Start Date: 9/28/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 10/7/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

20 BR 11-10-31

170

Identify as per dwg & Stock Location 435

0.00



Packaging

Memo

0.00

Packaging

11/10/11 S/200

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/11/01 J

MF 11-11-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, September 28, 2011 3:24:36 PM

Page 1

Work Order ID: 74352



Parent Item: D2661-1



Parent Item Name: Saddle, LH Fwd Aft Out 206

Start Date: 9/28/2011

Required Date: 10/7/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP: C00.11.01 Removed P/O for Powder Coat - in house process EC
IPP Rev:D As per Rev D 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D6101-003		Manufactured	No			100	Each	73.0000	1	20			
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Saddle Billet, 7075



20 11.10.24

Location

Loc Qty

Loc Code

MAT040

8

72226

8

MAT44

65

72226

5

73769

60

73780

20

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR: Yes No** **DQA:** _____ **Date:** _____
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 74352
Description: 206 Saddle, Outboard, Left side	Part Number: D2661-1
Inspection Dwg: D2661 Rev. D	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2661 Rev. D and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.132	.122	.132	.132		
B	0.100	0.140		.124	.124	.124	.124		
C	1.250	1.270		1.136	1.136	1.136	1.136		
D	0.615	0.685		.685	.685	.685	.685		
E	0.240	0.260		.251	.251	.251	.251		
F	1.437	1.487		1.324	1.324	1.324	1.324		
G	0.210	0.230		.224	.224	.224	.224		
H	0.100	0.180		.136	.136	.136	.136		
I	2.470	2.510		2.491	2.491	2.491	2.491		
J	1.565	1.585		1.576	1.576	1.576	1.576		
K	0.235	0.240		.238	.238	.238	.238		
L	0.100	0.120		.107	.107	.107	.107		
M	0.990	1.010		1.000	1.000	1.000	1.000		
N	0.510	0.515		.513	.513	.513	.513		
O	5.990	6.010		5.997	5.997	5.997	5.997		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.313	0.318		.314	.314	.314	.314		
S	0.315	0.322		.316	.316	.316	.316		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.364	1.364	1.364	1.364		
V	0.787	0.807		.797	.797	.797	.797		
W	0.540	0.560		.550	.550	.550	.550		
X	1.674	1.684		1.679	1.679	1.679	1.679		
Y	0.257	0.262		.257	.257	.257	.257		
Z	0.912	0.932		.917	.917	.917	.917		
AA	0.490	0.510		.499	.499	.499	.499		
AB	0.178	0.198		.188	.188	.188	.188		
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: <u>RF</u>
Date: <u>11-16-23</u>

Audited by: <u>D.A</u>
Date: <u>11/10/27</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	74352
Description: 206 Saddle, Outboard, Left side		Part Number:	D2661-1
Inspection Dwg: D2661 Rev. D		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2661 Rev. D and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				15	16	17	18		
A	0.100	0.140		.132	.132	.132	.132		
B	0.100	0.140		.124	.124	.124	.124		
C	1.250	1.270		1.137	1.137	1.137	1.137		
D	0.615	0.685		.685	.685	.685	.685		
E	0.240	0.260		.251	.251	.251	.251		
F	1.407	1.407		1.324	1.324	1.324	1.324		
G	0.210	0.230		.224	.224	.224	.224		
H	0.100	0.180		.136	.136	.136	.136		
I	2.470	2.510		2.491	2.491	2.491	2.491		
J	1.565	1.585		1.576	1.576	1.576	1.576		
K	0.235	0.240		.238	.238	.238	.238		
L	0.100	0.120		.107	.107	.107	.107		
M	0.990	1.010		1.000	1.000	1.000	1.000		
N	0.510	0.515		.513	.513	.513	.513		
O	5.990	6.010		5.997	5.997	5.997	5.997		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.313	0.318		.314	.314	.314	.314		
S	0.315	0.322		.316	.316	.316	.316		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.364	1.364	1.364	1.364		
V	0.787	0.807		.797	.797	.797	.797		
W	0.540	0.560		.500	.500	.500	.500		
X	1.674	1.684		1.677	1.677	1.677	1.677		
Y	0.257	0.262		.257	.257	.257	.257		
Z	0.912	0.932		.917	.917	.917	.917		
AA	0.490	0.510		.499	.499	.499	.499		
AB	0.178	0.198		.188	.188	.188	.188		
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	RF
Date:	11-10-23

Audited by:	M.A
Date:	11/10/23

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

DART AEROSPACE LTD		Work Order:	74352
Description: 206 Saddle, Outboard, Left side		Part Number:	D2661-1
Inspection Dwg: D2661 Rev. D		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2661 Rev. D and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				#9	#10	#11	#12		
A	0.100	0.140		.132	.132	.132	.132		
B	0.100	0.140		.124	.124	.124	.124		
C	1.250	1.270		1.137	1.137	1.137	1.137		
D	0.615	0.685		.685	.685	.685	.685		
E	0.240	0.260		.251	.251	.251	.251		
F	1.437	1.467		1.324	1.324	1.324	1.324		
G	0.210	0.230		.224	.224	.224	.224		
H	0.100	0.180		.136	.136	.136	.136		
I	2.470	2.510		2.491	2.491	2.491	2.491		
J	1.565	1.585		1.576	1.576	1.576	1.576		
K	0.235	0.240		.238	.238	.238	.238		
L	0.100	0.120		.107	.107	.107	.107		
M	0.990	1.010		1.000	1.000	1.000	1.000		
N	0.510	0.515		.513	.513	.513	.513		
O	5.990	6.010		5.997	5.997	5.997	5.997		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.313	0.318		.314	.314	.314	.314		
S	0.315	0.322		.316	.316	.316	.316		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.364	1.364	1.364	1.364		
V	0.787	0.807		.797	.797	.797	.797		
W	0.540	0.560		.550	.550	.550	.550		
X	1.674	1.684		1.679	1.679	1.679	1.679		
Y	0.257	0.262		.257	.257	.257	.257		
Z	0.912	0.932		.917	.917	.917	.917		
AA	0.490	0.510		.499	.499	.499	.499		
AB	0.178	0.198		.188	.188	.188	.188		
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	RF
Date:	11-10-23

Audited by:	A.A
Date:	11/10/23

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

DART AEROSPACE LTD		Work Order:	74352
Description: 206 Saddle, Outboard, Left side		Part Number:	D2661-1
Inspection Dwg: D2661 Rev. D		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2661 Rev. D and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	13	14	15	16		
A	0.100	0.140		.130	.129	.129	.129		
B	0.100	0.140		.124	.124	.124	.124		
C	1.250 1.125-1.145	1.270		1.135	1.137	1.137	1.137		
D	0.615	0.685		.675	.675	.675	.675		
E	0.240	0.260		.250	.250	.250	.249		
F	1.437 1.313-1.343	1.467		1.323	1.322	1.322	1.323		
G	0.210	0.230		.220	.223	.224	.224		
H	0.100	0.180		.135	.140	.140	.140		
I	2.470	2.510		2.490	2.490	2.490	2.490		
J	1.565	1.585		1.574	1.575	1.575	1.575		
K	0.235	0.240		.237	.237	.237	.237		
L	0.100	0.120		.115	.110	.108	.108		
M	0.990	1.010		1.000	1.000	1.000	1.000		
N	0.510	0.515		.512	.512	.512	.512		
O	5.990	6.010		5.997	5.997	5.997	5.997		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.313	0.318		.315	.315	.315	.315		
S	0.315	0.322		.317	.317	.317	.317		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.787	0.807		.794	.797	.796	.796		
W	0.540	0.560		.545	.546	.547	.545		
X	1.674	1.684		1.679	1.679	1.679	1.679		
Y	0.257	0.262		.258	.258	.258	.258		
Z	0.912	0.932		.920	.915	.914	.917		
AA	0.490	0.510		.497	.497	.497	.498		
AB	0.178	0.198		.188	.188	.188	.188		
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	<i>mf</i>
Date:	11/10/25

Audited by:	H.A
Date:	11/10/27

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

DART AEROSPACE LTD		Work Order: 74352
Description: 206 Saddle, Outboard, Left side		Part Number: D2661-1
Inspection Dwg: D2661 Rev. D		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2661 Rev. D and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	17	218	PM	A20		
A	0.100	0.140		.128	.128	.128	.128		
B	0.100	0.140		.125	.124	.124	.125		
1.125-1.145 C	1.250	1.270		1.137	1.137	1.137	1.137		
D	0.615	0.685		.675	.675	.675	.679		
E	0.240	0.260		.250	.249	.249	.249		
1.313-1.343 F	1.437	1.467		1.324	1.323	1.323	1.323		
G	0.210	0.230		.223	.223	.223	.223		
H	0.100	0.180		.140	.140	.140	.140		
I	2.470	2.510		2.490	2.490	2.490	2.490		
J	1.565	1.585		1.576	1.575	1.575	1.575		
K	0.235	0.240		.236	.237	.238	.237		
L	0.100	0.120		.106	.107	.108	.110		
M	0.990	1.010		1.000	1.006	1.000	1.000		
N	0.510	0.515		.512	.512	.512	.512		
O	5.990	6.010		5.997	5.997	5.997	5.997		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.313	0.318		.315	.315	.315	.315		
S	0.315	0.322		.317	.317	.317	.317		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.787	0.807		.796	.797	.796	.795		
W	0.540	0.560		.545	.547	.547	.546		
X	1.674	1.684		1.679	1.679	1.679	1.679		
Y	0.257	0.262		.258	.258	.258	.258		
Z	0.912	0.932		.915	.915	.916	.917		
AA	0.490	0.510		.498	.498	.497	.497		
AB	0.178	0.198		.188	.188	.188	.188		
AC									
AD									
AE									
AF									
Accept/Reject									

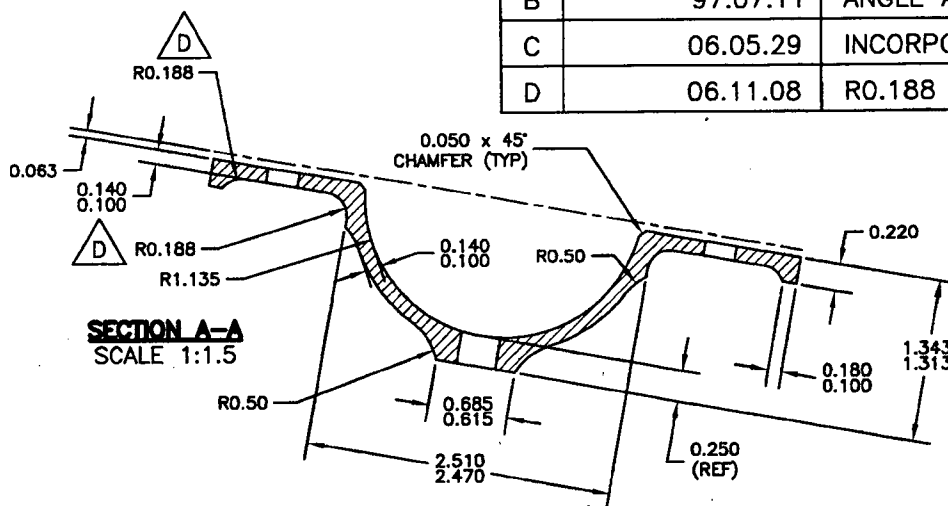
Measured by: <i>amp</i>
Date: 11/10/25

Audited by: <i>H.A.</i>
Date: 11/10/27

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

DART

DESIGN #1	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED #1	DRAWING NO. D2661	REV. D SHEET 1 OF 1
DATE 06.11.08		TITLE SADDLE OUTSIDE	SCALE 1:3
A	97.03.25	NEW ISSUE	
B	97.07.11	ANGLE AND NOTES ADDED	
C	06.05.29	INCORPORATE DEO 9122, 9102, 9095	
D	06.11.08	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313	



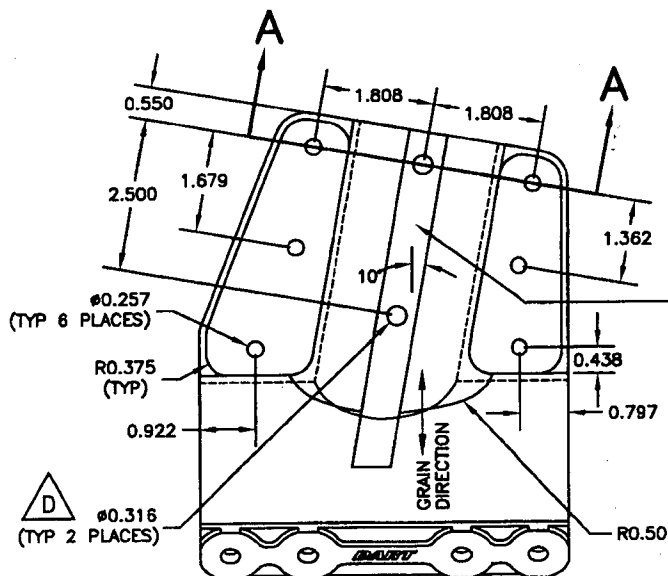
RELEASED

07.02.12 #1

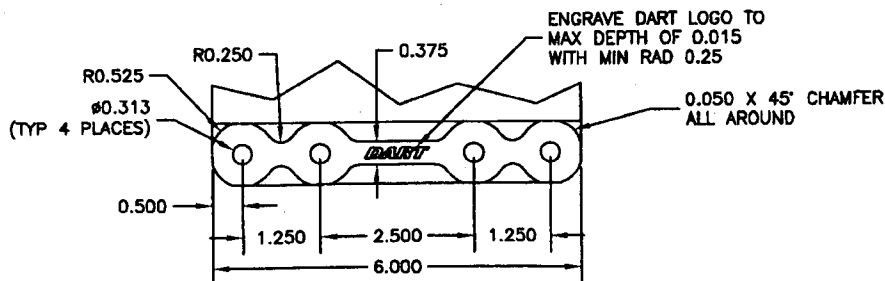
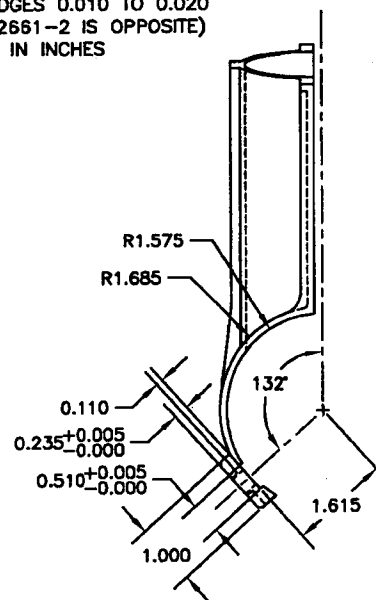
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12) (MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2661-1 SHOWN (D2661-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES



ENGRAVE PART
NUMBER AND
BATCH NUMBER
TO MAX DEPTH
OF 0.010 WITH
MIN RADIUS
OF 0.010

**D2661-1 SADDLE OUTSIDE**

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries